

Date: Friday, 11/07/2008 10:25:17 AM
 User: Julie Lecocq

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPAD |
| Job Number : 40438 | |
| Estimate Number : 10700 | |
| P.O. Number : | Part Number : D34291 |
| This Issue : 11/07/2008 S.O. No. : | Drawing Number : D3429 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : // Type : PURCHASED PARTS | Drawing Revision : A |
| Previous Run : 39789 | Material : |
| Written By : | Due Date : 31/07/2008 Qty: 12 Um: Each |
| Checked & Approved By : <u>JUL 08.7.11</u> | |
| Comment : Est: A 05.10.04 New Issue KJ/EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 0.1512 sf(s)/Unit Total: 1.8144 sf(s)

1010/1025/A21/6aA steel sheet 0.063" thick

Batch: 105706 B 8-7-16

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3429

Dwg Rev: A

Prog Rev: A

B 8-7-16

(13)

2-Deburr if necessary

B 8-7-16

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



B 8-7-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

S 08/07/16 (13)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1

Form Joggle as per Dwg D3429 on brake using Jig DT8158

SP 07/07/17

(13)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:25:18 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40438

Part Number: D34291

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

8 08/07/22 (413)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 560 Hardcoat M106762
Weld hardcoat as per Dwg D3429

FL 8-7-22

P10

N6

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 08-07-22

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/07/22 (414)

10.0

POWDER COATING

POWDER COATING



M106442



11X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
320
3:45

M-L 08/07/22

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-22

11

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 17

M-L 08/07/22

11X

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3429-1 PAR #: N/A Fault Category: Prod / Pwr. Loss NCR: (Yes) No DQA: D Date: 08/07/09
 QA: N/C Closed: D Date: 08/07/09

| NCR: <u>40438</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|-----------|--|-----------------------------|---|----------------------------|---------------------------------------|---------------------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>08/07/09</u> | <u>20</u> | After starting welder noticed that his the welding Rod was not reacting as normal to the work plate. He then realized he was using Stainless Steel Rod (Stainless steel). R.C welder pulled Rod that was left on his table from the right Beler without verifying type prior to use. Qty 2 parts affected. | <u>[Signature]</u> | SCRAP Destroyed and no Replaced was replaced <u>Qty 2</u> | <u>EL</u> <u>8-7-20</u> | <u>[Signature]</u> <u>08/07/09</u> | <u>[Signature]</u> <u>08/07/09</u> | |
| | | | <u>[Signature]</u> | Remind employee to be more cautious when using welding Rods left on table. | <u>EL</u> <u>8-7-20</u> | <u>[Signature]</u> <u>08/07/09</u> | <u>[Signature]</u> <u>08/07/09</u> | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/07/2008 10:25:18 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40438

Part Number: D34291

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/23 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

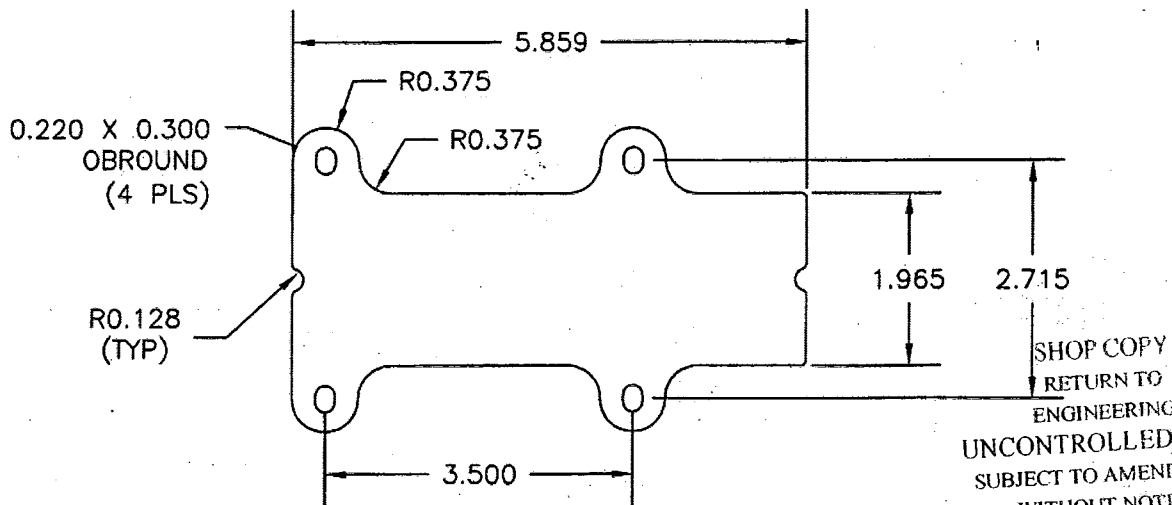
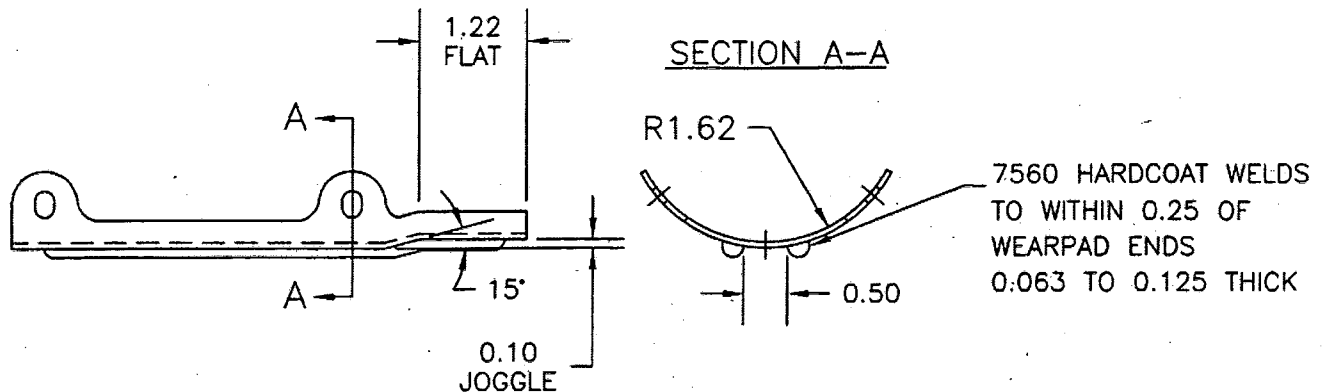
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|--|---|--|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED  | APPROVED  | DRAWING NO. D3429 | REV. A SHEET 1 OF 1 |
| DATE 05.04.18 | | TITLE WEARPAD | SCALE 1:2 |
| A | 05.04.18 | NEW ISSUE | |

RELEASED
05.09.06-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40438

D3429-1 WEARPAD

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

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